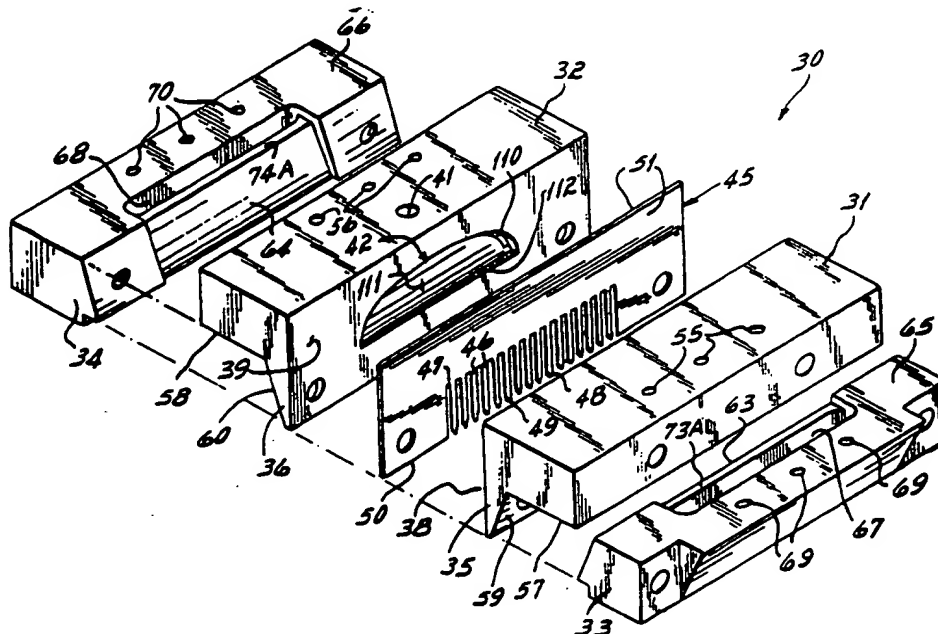




## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification <sup>5</sup> : <b>B05B 1/16, B05D 1/12</b>		<b>A1</b>	(11) International Publication Number: <b>WO 94/01221</b>
			(43) International Publication Date: <b>20 January 1994 (20.01.94)</b>
(21) International Application Number: <b>PCT/US93/06434</b> (22) International Filing Date: <b>8 July 1993 (08.07.93)</b> (30) Priority data: <b>07/910,784</b> <b>8 July 1992 (08.07.92)</b> <b>US</b> (71) Applicant: <b>NORDSON CORPORATION [US/US]; 28601 Clemens Road, Westlake, OH 44145 (US).</b> (72) Inventors: <b>GILL, Michael, L.; 3145 Creekside Drive, Westlake, OH 44145 (US). BENECKE, Jorgen; Brandenburger Strasse 7, D-21339 Lüneburg (DE). CIEPLIK, Arthur; Feldstrasse 3, D-2120 Lüneburg (DE). BURMESTER, Thomas; Sonnenweg 34, D-2122 Bleckede (DE).</b>		(74) Agents: <b>STALLARD, David, S. et al.; Wood, Herron &amp; Evans, 2700 Carew Tower, Cincinnati, OH 45202 (US).</b> (81) Designated States: <b>AT, AU, BB, BG, BR, BY, CA, CH, CZ, DE, DK, ES, FI, GB, HU, JP, KP, KR, KZ, LK, LU, MG, MN, MW, NL, NO, NZ, PL, PT, RO, RU, SD, SE, SK, UA, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).</b>	
		<b>Published</b> <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>	

(54) Title: SEGMENTED SLOT DIE FOR AIR SPRAY OF FIBERS



## (57) Abstract

A slot die for producing a fibrous web of adhesive material includes a segmented shim having a plurality of fingers in said slot dividing adhesive material into a plurality of adhesive streams. The fingers have tapered ends which are flush with or extend slightly beyond the slot nozzle outlet. Separate material streams emanate from the slot nozzle outlet where they merge and are engaged by air flow producing a fibrous web of adhesive material. The adhesive and air flow are started and stopped at intervals to produce discrete fibrous webs having square, sharp leading and trailing edges.

**FOR THE PURPOSES OF INFORMATION ONLY**

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	FR	France	MR	Mauritania
AU	Australia	GA	Gabon	MW	Malawi
BB	Barbados	GB	United Kingdom	NE	Niger
BE	Belgium	GN	Guinea	NL	Netherlands
BF	Burkina Faso	GR	Greece	NO	Norway
BG	Bulgaria	HU	Hungary	NZ	New Zealand
BJ	Benin	IE	Ireland	PL	Poland
BR	Brazil	IT	Italy	PT	Portugal
BY	Belarus	JP	Japan	RO	Romania
CA	Canada	KP	Democratic People's Republic of Korea	RU	Russian Federation
CF	Central African Republic	KR	Republic of Korea	SD	Sudan
CG	Congo	KZ	Kazakhstan	SE	Sweden
CH	Switzerland	LI	Liechtenstein	SI	Slovenia
CI	Côte d'Ivoire	LK	Sri Lanka	SK	Slovak Republic
CM	Cameroon	LU	Luxembourg	SN	Senegal
CN	China	LV	Latvia	TD	Chad
CS	Czechoslovakia	MC	Monaco	TG	Togo
CZ	Czech Republic	MG	Madagascar	UA	Ukraine
DE	Germany	ML	Mali	US	United States of America
DK	Denmark	MN	Mongolia	UZ	Uzbekistan
ES	Spain			VN	Viet Nam
FI	Finland				

-1-

SEGMENTED SLOT DIE FOR AIR SPRAY OF FIBERS

This case is generally related to the following United States Patent Applications filed on even date herewith:

	<u>Title</u>	<u>Inventors</u>
	Apparatus & Methods for Applying Discrete Coating Serial No. _____	J.Benecke; A.Cieplik; T.Burmester
5	Apparatus & Methods for Applying Discrete Foam Coatings Serial No. _____	J.Raterman; J.Benecke; A.Cieplik; T.Burmester; M.Gill
10	Methods & Apparatus for Applying Coatings to Bottles Serial No. _____	L.Hauser; J.Benecke; A.Cieplik; T.Burmester; M.Gill; K.Washington; R.Evans
15	Apparatus & Methods for Applying Conformal Coatings to Electronic Circuit Boards Serial No. _____	B.Boger; J.Benecke; A.Cieplik; T.Burmester; M.Gill
20	Apparatus & Methods for Intermittently Applying Discrete Adhesive Coatings Serial No. _____	J.Raterman; J.Benecke; A.Cieplik; T.Burmester; M.Gill

Such applications are expressly incorporated herein by reference.

This invention relates to the application of fibrous coatings to substrates and more particularly to the application to substrates of discrete, uniform

-2-

fibrous adhesive coatings having sharp, square cut-on and cut-off edges.

Many industrial manufacturing processes require the application of fibrous or solid film adhesive coatings to substrates. For example, in the application of non-woven absorbent pads to impervious plastic web substrates, an application of adhesive is used to bond the two substrates together.

Such fibrous applications have in the past been applied in parallel fine lines, in swirl patterns or in random fibrous fashion by means of a melt-blown slot die apparatus such as disclosed in U.S. Patent No. 4,720,252. Such apparatus provides a non-woven fibrous web in low basis weights and is stated to reduce clogging due to the use of a slot die as opposed to a plurality of small opening nozzles for each fibrous component. Small particles are said to pass the slot die, which might otherwise clog a single fiber nozzle orifice.

When such dies are used to produce low basis weight coatings, the slot thickness must be held at a narrow distance, which still may block slightly larger particles, resulting in clogging. Also, when adhesive is extruded through the slot, the extruded web tends to draw in or neck-in at the edges. This produces a "rail roading" effect in the deposited web, i.e. thickened edges and thinner center portions. While the air

-3-

blowing on the web tends to reduce this effect, it can still be pronounced, and is undesirable.

Moreover, such melt blowing apparatus is generally used in the production of non-woven webs and not in adhesive coatings in lamination.

In the production of discrete coatings and adhesives for lamination of discrete substrate areas, for example, it is desirable to obtain broad, uniform fibrous coatings in a non-contact application process with sharp, square, cut-on and cut-off edges with no stringing of material. None of the processes currently known are entirely suitable for this application.

Many various devices have been used to apply adhesives for lamination, including curtain coaters, contact coaters, spray coaters, and, more recently, fine line or spiral pattern application devices. Curtain coaters do not generally produce good cut-on, cut-off edges and are subject to neck-in. Contact coaters present the inherent disadvantage of wear and substrate index and tension tolerances. The spray, fine line and spiral pattern applicators do not generally produce highly defined square edge cut-on and cut-off coating edges in a uniform broad coating, as are desired in a number of applications.

Accordingly, it has been one objective of the invention to provide an improved slot die apparatus for the deposition of solid or fibrous adhesive layers or coatings.

-4-

A further objective of the invention has been to provide an improved slot die for the spraying of uniform low basis weight, fibrous adhesive coatings yet with minimal clogging compared with prior slot die apparatus.

5

It has been a further objective of this invention to produce improved broad, uniform, fibrous hot melt adhesive coatings with sharp side edges and sharp and square leading and trailing edges on intermittently presented discrete substrate areas.

10

Another objective of this invention has been to provide improved methods and apparatus for intermittent non-contact application of fibrous thermoplastic coating material, having sharp, square, side, leading and trailing edges, to discrete, predetermined areas.

15

To these ends, a preferred embodiment of the invention includes a slot nozzle, elongated air channels on each side of the slot nozzle for impinging a flow of air on each side of an expanse of coating material extruding from the slot nozzle, and a segmented or comb-like shim in the die slot having a plurality of elongated slots through which adhesive material moves. Upon emerging from the die, the adhesive merges and is blown by the air onto a uniform fibrous web for coating an underlying substrate. Means are provided for controlling the supply of material to the slot nozzle and the supply of air to the air

20

25

-5-

channels so that each can be initiated and stopped at predetermined intervals to produce sharp, square leading and trailing edges in the deposited coatings.

5 The invention produces uniform, solid or fibrous, wide or broad coatings having sharp side edges and sharp, square, leading and trailing edges coordinated with a predetermined underlying substrate area and applied in a non-contacting application process.

10 These and other objectives and advantages will become readily apparent from the following detailed description of a preferred embodiment of the invention and from the drawings in which:

15 Fig. 1 is a diagrammatic side view in partial cross-section illustrating apparatus according to the invention;

Fig. 2 is an elevational side view in partial cross section of a slot nozzle coater according to the invention;

20 Fig. 3 is an elevational front view in partial cross-section of the apparatus of Fig. 2, illustrating diagrammatically control and flow features of the invention;

25 Fig. 4 is an exploded view of the slot nozzle die of Fig. 2, showing the segmented shim of the invention;

-6-

Fig. 5 is a diagrammatic view illustrating use of one embodiment of the invention in a book binding application;

Fig. 6 is a front view of the slotted or segmented shim used in the slot nozzle die of the invention;

Fig. 6A is a front view of an alternate shim;

Fig. 7 is a graph illustrating coating weight applied v. substrate line speed for a coater according to the invention; and

Fig. 8 is an illustrative view showing discrete fibrous coatings applied to a substrate according to the invention.

#### SPECIFICATION

Turning now to the drawings, there will now be described the apparatus for generating discrete, uniform coatings having sharp, square cut-on and cut-off edges. According to the invention, such coatings are either open, fibrous or porous coatings, or, on the other hand, are solid films. Moreover, such coatings can be formed from glue or adhesive materials, such as hot melt adhesives, or from cold glues, paints, or other materials of adhesive or non-adhesive nature. The invention will be described herein in terms of its use with hot melt adhesive. Fig. 1 illustrates various features of a die means 30 and air and hot melt adhesive controls according to the invention. The die means 30 comprises two die halves 31, 32, and two air



-7-

blocks 33, 34. Each die block 31, 32 includes a downwardly depending projection 35, 36. The die halves 31, 32 define between them an extrusion slot 37. Slot 37 is defined by the face 38 of the die half 31 and the face 39 of the die half 32. Face 38 is juxtaposed with respect to the face 39, as shown. The extrusion slot 37 terminates at an elongated slot nozzle or extrusion outlet 40. As noted in the Figures, the air blocks extend below the outlet 40 to provide a degree of protection from mechanical damage.

Die half 32 includes a hot melt passageway 41 for receiving hot melt adhesive and conducting the hot melt adhesive to a "coat hanger" portion 42 of the die half 32, details of which are perhaps better seen in Fig. 4. A slotted or segmented shim 45, as best seen in Fig. 6, and a portion of which is seen in Fig. 1, is located between the juxtaposed surfaces 38 and 39 of the die halves 31 and 32. The shim 45 has a plurality of elongated projections 46, defining between them a plurality of elongated channels or slots 47.

Each of the projections has a downstream tapered end portion 48, having a preferably sharp tip 49 which is preferably flush with the lower edge 50 of the shim, and flush with the elongated slot nozzle extrusion outlet 40 (Fig. 1). Tips 49 could be disposed just internally of outlet 40. In Fig. 1, only the top portion 51 of the shim 45 is shown, for the purpose of clarity. Alternatively, an open shim can be

used. A further alternate shim 45 is shown in Fig. 6A. Shim 45a has tips 52 which extend beyond outlet 40 preferably about two to three thousandths of an inch.

Fig. 6A illustrates an alternative shim wherein the tips 52 are tapered to a point, extending slightly beyond shim edge 50, opposed to flush tips 49 of Fig. 6. Tips 52 extend in the embodiment preferably two or three thousandths of an inch beyond the slot nozzle extrusion outlet 40. Otherwise, this shim is the same as that of Fig. 6.

In any event, the tips of the projections 46 are preferably sharply pointed, although they could be blunted, and the tips extend to a position proximate outlet 40.

Returning now to Fig. 1, each of the upper die halves 31, 32 is provided with an air passageway 55, 56, extending from an upper surface of the die to a lower respective surface 57, 58. Each die half 31, 32 also includes an inclined surface 59, 60, depending from the surfaces 57 and 58, respectively. The inclined surfaces 59 and 60 define one part of an air passage, or air slot 61 and 62, as will be described.

Turning now to the air blocks 33 and 34, it will be appreciated that each of them include an inclined surface 63 and 64, respectively, which define the other side of the air slots 61 and 62 with the juxtaposed respective surfaces 59, 60, all as shown in Fig. 1. Each of the air blocks 33 and 34 include an

-9-

upper surface 65, 66 juxtaposed to the respective lower surfaces 57 and 58 of the die halves 31, 32.

An elongated air plenum 67, 68 is formed in each of the air blocks 33, 34. The plenums 67, 68 are also seen in Fig. 4. Respective air passages 69 and 70 are formed in the respective air blocks 33 and 34 and extend from the respective surfaces 65 and 66 to a lower portion 71, 72 of the respective plenums 67, 68. Each of the plenums 67, 68 are primarily defined in the air blocks 33 and 34. However, when the die means 30 are assembled, the top area of each of the respective plenums 67, 68 are defined respectively by the lower surfaces 57 and 58 of the die halves 31, 32. These surfaces 57, 58 also form an upper portion of air passage 73 and 74, each of which respectively lead from their associated plenums 67 and 68 to the air slots 61 and 62. Accordingly, looking at the right hand side of Fig. 1, it will be appreciated that air can pass through the passageway 55 to the passageway 69 in air block 33, and from there to the plenum 67. "O"-rings, not shown, can be used at the interfaces of the respective die half and air block to seal passages 55, 56 with passages 69, 70, respectively. Pressurized air in the plenum 67 moves through the passageway 73 into the air slot 61.

In a like manner, air can be introduced to passageway 56 in the die half 32 and from there it can move into the air passageway 70 and into the lower

-10-

portion of the plenum 68. From the plenum 68, pressurized air is directed through the air passage 74 into the air slot 62 of the air block 34.

Referring now briefly to the upper portion of Fig. 1, it will be appreciated that a controller 75 is operationally connected to valves V-1 and V-2, as shown, for controlling the introduction of heated, pressurized air to the passages 55 and 56, respectively, in order to pressurize those passages and the downstream air passages as previously described, with air. At the same time, the controller 75 is operationally interconnected to a hot melt control valve 76 for controlling the supply of coating material, such as hot melt adhesive, to the hot melt adhesive passage 41 and to the internal coat hanger area 42 of the die means 30. While any suitable form of controller 75 can be used, as is well known, one particular controller comprises a PC-10 pattern controller, manufactured by The Nordson Corporation of Westlake, Ohio. The PC-10 pattern control 75 is operational to initiate and to stop the generation of air into passages 55 and 56, either simultaneously or independently, and also to initiate and to stop the hot melt flowing through valve 76 so as to intermittently provide coating material to the passageway 41 independently and at pre-selected times with respect to the provision of pressurized heated air to the passages 55 and 56 all in a manner as will be described.

-11-

The air slots 61 and 62 are oriented on an angle with respect to the elongation of the extrusion slot 37. Accordingly, when coating material is extruded through the slot 37 and outwardly of the extrusion outlet 40, air moving through the air slots 61 and 62 is impinged on the material before that material engages or is deposited on an underlying substrate which is presented for coating.

Turning now to Figs. 2 and 3, there is shown more of the overall extrusion apparatus according to the invention. As shown in Fig. 2, the die means 30 is interconnected with air valves V-1, V-2 and hot melt valve 76, each of which is interconnected with an extrusion body 80 which operationally interconnects the air and hot melt valves with the die means 30.

For clarity, a portion of the air valve V-2 is shown in partial cross section in Fig. 2. Since the valves V-1 and V-2 are identical, only valve V-2 will be described. Such air valves are manufactured and distributed by The Nordson Corporation through Nordson Engineering of Luneberg, Germany, under part no. 265701. Any other suitable valve can be used.

Valve V-2 comprises a valve body 82 defining a valve chamber 83 and a control chamber 84, the two chambers being separated by the diaphragm 85. An extension 86 having a bore 87 extending therethrough depends from the valve body 82 and extends into the bore 88 of extrusion body 80 to form an annular chamber

-12-

89 therewith. Chamber 89 is interconnected with an annular passageway 90 in the valve body 82, which interconnects with the chamber 83. An annular chamber 91 is also defined in the valve body 82 and interconnects with the chamber 83. When control air is directed into chamber 84, the diaphragm 85 is pushed downwardly to seal off the annular passage 90 from the annular passage 91. On the other hand, when pressure is decreased in the control chamber 84, the diaphragm moves upwardly to the position shown in Fig. 3. Air in the inlet annular chamber 89, which is heated and under pressure, communicates through the annular passages 90 through the chamber 83 and the annular passage 91, into the outlet bore 87. Outlet bore 87 is connected through a passageway 92 to the air passage 56 in the upper die half 32, as shown in detail in Fig. 1, where the air from there can move to the plenum 68 and into the air slot 62.

In like manner, the air valve V-1 is operable to selectively supply air to the air passage 93 in the extrusion body 80 and from there to the air passage 55 in the upper die half 31. Air moves through that passageway 55 into the plenum 67 and from there to the air slot 61.

The hot melt valve 76 can be any suitable hot melt valve which can be selectively controlled to initiate and to cut off the flow of coating material, such as hot melt adhesive, to the die means 30. One

-13-

such suitable valve is balanced valve model no. EP51 produced by The Nordson Corporation of Westlake, Ohio. Such valve minimizes significant change in pressures when the valve is switched between its opened and closed positions. The valve 76 has a stem 96 seated over a port 97. When control air is supplied to an inlet 98, the stem 96 is lifted to permit hot melt adhesive in a chamber 99 to flow through the port 97 and into the hot melt passageway 41 of the upper die half 32. Hot melt adhesive is introduced into the chamber 99 through hot melt inlet 100. A hot melt outlet 101 is also interconnected with the chamber 99 to receive pressurized hot melt adhesive when the stem 96 is seated on port 97.

Any suitable apparatus can be utilized for melting and pumping hot melt adhesive to the valve 76. Such apparatus is shown diagrammatically at 102. While any suitable apparatus could be utilized, one particular form of apparatus which is suitable is the model HM640 applicator, manufactured by The Nordson Corporation of Westlake, Ohio.

Fig. 3 illustrates diagrammatically the various control inputs to the valves 76 and V-1. As shown in Fig. 3, the controller 75 is interconnected to a control air supply 105 for supplying control air to the valves V-1 and V-2. A pressurized air source 106 is interconnected to an air heater 107 which supplies process air to the valves V-1 and V-2 for transmission

-14-

to the respective air slots 61, 62, as described above. When the respective valves V-1 and V-2 are opened, controller 75 is also interconnected to the control air supply for supplying control air through closed and  
5 opened solenoid control valves (shown in Fig. 3) to open and close the hot melt valve 76.

Referring now more particularly to Fig. 1 and the details of the die means 30 as shown in Fig. 4, it will be appreciated that the plenums 67 and 68 in the  
10 air blocks 33, 34 communicate with the lower surfaces 73A and 74A, respectively, of the air passages 73 and 74 as previously described, and air emanating from the upper portion of the plenums 67 and 68 moves through the passageways 73 and 74 and then downwardly through  
15 the respective air slots 61, 62.

Turning now to the so-called "coat hanger" portion 42 of the upper die half 32, and with reference to Fig. 4, it will be appreciated that "coat hanger" dies are known in general. For example, one coat  
20 hanger-type die for handling hot melt adhesive is disclosed in U.S. Patent No. 4,687,137, expressly incorporated herein by reference. The difference in that structure is that it serves to provide a plurality of discrete beads, and not a continuous web of solid or  
25 fibrous adhesive as noted herein. While such a die could be used herein, nevertheless, the present die means 30 incorporates a "coat hanger" portion 42 having an arcuate slot or groove of increasingly shallow



-15-

dimension 110 communicating with an incline surface 111. Surface 111 is inclined such that its lower portion, where it meets bottom surface 112, is closer to the plane of the face 39 than is the upper portion.

5 It will also be appreciated that slot 110 is of decreasing depth as its distance from port 113 continues until it flows unbroken in surface 111. The arcuate slot 110 of decreasing depth is fed by the hot melt port 113, which is interconnected to the hot melt

10 passage 41. In use, when hot melt is supplied at pressure to the passage 41, it exudes through the port 113 into the arcuate slot 110 and from there flows over the surface 111 and spreads out throughout the relieved coat hanger shaped portion 42 of the die face 39 and

15 the side of the shim 45 which is juxtaposed to the face 39 of the die half 32.

It will be appreciated that the slots 47 of shim 45 have upper ends which communicate with the lower portion of the coat hanger die area 42, just

20 above the surface 112 thereof, so that hot melt adhesive or other coating material can flow into the slots 47 and then downwardly to the extrusion outlet 40. In this manner, the coating material is spread throughout the coat hanger portion 42 and across each

25 of the upper ends of the slots 47 of the shim 45 at significantly equal pressures, so that coating material can move through the extrusion slot 37 within the slots 47 of the shim 45 at relatively equal pressures.

-16-

As illustrated diagrammatically in Fig. 6, the material exudes through the slots 47 and then outwardly of the extrusion outlet 40.

5 Considering the advantages of the segmented shim 45, it will be appreciated that the width of the slots 47 between the projections 46 is preferably about twice the thickness of the shim 45. The thickness of one shim 45 may be about .004" while the slot width, i.e. from one projection 46 across to the next  
10 projection 46, is about .008". In another shim 45, for example, the shim thickness is about .008" while the segmented slot width between juxtaposed projections is about .016"

Accordingly, the overall slot thickness  
15 between die faces 38, 39 can be doubled while the die still produces the same basis weight coating as a prior slot die where the die slot is not segmented, as in this invention. Thus in a prior slot die where a slot thickness of .002" was needed for a small basis weight  
20 coating, the present invention can obtain the same basis weight coating with a slot thickness of .004", or doubled. Thus, the slot die according to the invention could pass a potentially clogging particle of .003" while the prior continuous slot die would not (for the  
25 same basis weight coating to be produced).

While the ratio of the slot width to the shim thickness is preferably about 2 to 1, this ratio can be varied to produce varying coating thicknesses.

-17-

It will be appreciated that the width and thickness parameters of the shims 45, 45a and their components can widely vary. The parameters may vary due to the basis weight of coating per square meter desired, the cohesiveness desired, the coating material viscosity or other factors.

In order to provide further description of one form of coat hanger portion 42, the surface 112 from face 39 back to surface 111 is about .020" wide. The tops of slots 47 are about .050" when the shim is operably disposed between faces 38, 39. The groove 110 at its deepest depth from face 39 is about .125" from face 39. The surface 111 at its top area is about 1/16" deep from face 111 and about .020" back from surface 39 at its bottom. The coat hanger width across face 39 is about 38 mm.

It will be appreciated that the coating material may be precisely delivered to the heads or nozzles by one or more material metering means such as metering gear pumps. A single pump could feed a manifold for all the heads or nozzles or a separate metering gear pump could be used for each head or nozzle, or for a group of nozzles of less than all nozzles. This precise delivery permits accuracy in the material delivery so that accurate basis weight coatings can be provided for varying substrate speeds, for example. Any suitable form of metering feeds can be utilized. For example, U.S. Patents Nos. 4,983,109

-18-

and 4,891,249, expressly incorporated herein by reference, disclose metering means for hot melt adhesives.

Turning now to the use of the apparatus described above, for the application of coatings to defined predetermined or discrete substrates, it will be appreciated that the apparatus is capable of impinging hot air from the slots 61 and 62 on each side of the coating material exuding from the extrusion outlet 40. The impinging air engages and shreds the emerging expanse of coating material into discrete micro-denier fibers. Edge control is uniform and the density of the pattern can range from 25% open or fibrous to 0% open, i.e. a non-porous film. The parameters are selected depending on the application to which the coatings are to be applied. The controller 75 is operational to start and stop the application of air to the extruded coating material at different times and/or intervals compared to the starting and stopping of the delivery of hot melt adhesive to the extrusion outlet 40.

For example, in one preferred method of operation, the flow of air through the slots 61, 62 is started a short time prior to the time when the valve 76 is operated to initiate the delivery of coating material into the slot 37 and out through the outlet 40. The air is continued for the coating deposition. At the end of the deposition period, the valve 76 is

-19-

first operated to cease the extrusion of coating material through the outlet 40. After a short delay, the flow of air through the slot 61 and 62 is stopped. While the amount of delay in such an operation will vary, depending upon the properties of the hot melt, such time period generally will preferably be on the order of micro seconds. One example would be, for example, 1700 micro seconds between the start up of the air and the start up of the extrusion of the hot melt material, and 2100 micro seconds between the stopping of the hot melt material and the stopping of the air. Continuation of the air flow much beyond this time might serve to pull off remaining hot melt adhesive at the extrusion outlet and cause stringing of the deposited coating.

Moreover, it will also be appreciated that the invention contemplates the selective applications of air flow through either slot 61 or 62 individually or together during the deposition period, particularly to more accurately define the initial and ending contact position of the deposited coating on the substrate. One such mode of operation is illustrated in Fig. 5, where the apparatus is utilized, for example, to apply a discrete coating to the spine of a book so that a cover can be applied or laminated thereto.

In Fig. 5, a book having a spine with no adhesive thereon is shown at the left hand side of the

-20-

figure at position B-1. As illustrated at B-1, air flow has been initiated through slot 61 but there is no coating material being extruded through the slot 37 and no air flow has started through the air slot 62.

5 Moving to the book at the position B-2, it will be appreciated that the hot melt flow has started and that it is impinged by air flowing through slot 61. Since the air flowing through slot 61 moves downwardly in a general right to left direction as shown in Fig. 5, it

10 will be appreciated that the coating material does not string down the side of the book pages but is applied directly to the edge of the spine of the book with no stringing. Thereafter, and for most of the remainder of the coating operation, as shown in book position B-

15 3, air flow is initiated through the slot 62. At the end of the coating operation, the air flowing through slot 61 is terminated just before termination of the extrusion of the coating material (position B-4). Then, as shown in position B-5, the coating material

20 flow has ceased, while the air flowing through slot 62 continues for a short time period thereafter. This operation, when used in book binding, for example, would ensure that the adhesive will not string down the leading or rear sides or ends of the book.

25 Accordingly, with respect to Fig. 5, the lag air is started first and stopped first and the lead air, that is, with respect to the machine direction of the application as shown in Fig. 5, is started after

-21-

the extrusion of the coating material and stopped after the coating material extrusion has ceased. In this way, the air angling onto the coating material does not blow it in strings over the edges of the book, as would be undesirable and yet the cut-off and cut-on edges of the coating material are maintained in sharp, square fashion on the spine of the book.

While the coatings applied to a book spine for cover lamination may be solid and relatively thicker, lighter weight fibrous adhesive coatings are very useful in bonding or laminating substrates together, such as non-woven absorbent pads and impervious plastic backing sheets to make disposable absorbent pads and diapers. Fig. 8 illustrates the application of discrete fibrous coatings 10 to plastic web 11. The coatings have sharp, square leading and trailing edges 12 and 13 with no stringing. The low basis weight coatings when used for this application, provide the additional advantage of cost reduction. Substrate material is saved since its thickness can be reduced by virtue of the lower weight coatings which do not have as much tendency to burn through the substrates when applied. Accordingly, the substrates can be thinner and material saved.

The invention is believed useful with a wide range of coating materials of different viscosities, as shown by the following two examples.

-22-

ADHESIVE NO. 1

This adhesive had the following viscosities  
at the following temperatures:

5                   41,700 centipoise at 275 degrees F  
                  25,050 centipoise at 350 degrees F  
                  16,575 centipoise at 325 degrees F  
                  11,325 centipoise at 350 degrees F

10           Operating temperature was at 180 degrees C.. With  
            a 0.1 millimeter thick shim in the head, the supply  
            pressure was 20 BAR, the return pressure of the  
            adhesive was 21 BAR, and the air pressure was 1.5 BAR.  
            The air was turned on 2 millimeters of substrate travel  
            before the adhesive and turned off 2 millimeters of  
            substrate travel after the adhesive. Substrate line  
15           speed is about 150 meters/minute. This corresponds to  
            the delay times of about 800 micro seconds. At these  
            settings, the cut-on and cut-off were square and sharp  
            and a coating weight was produced of 5 grams per square  
            meter of uniform thickness.

20           ADHESIVE NO. 2

            This adhesive had the following viscosities:

            5,700 centipoise at 250 degrees F  
            2,600 centipoise at 275 degrees F  
            1,400 centipoise at 300 degrees F  
25           800 centipoise at 325 degrees F  
            550 centipoise at 350 degrees F



-23-

Operating temperature was 300 degrees F. Coating weight was 15 grams per square meter. Cut-on and cut-off were square and sharp with no stringing.

5 It is important in both these examples and other applications that the hot melt supply pressure and return pressure be maintained in a relationship, such that the differences of the two pressures are not more than 1 BAR.

10 In addition, it is believed, based on current information, that a minimum flow rate is required to produce a uniform pattern with square and sharp cut-ons and cut-offs. For example, in connection with a 38 millimeter wide pattern, it is possible to get down to at least 1 gram per square meter of coating weight at  
15 approximately 350 meters per minute of line speed. The graph in Fig. 7 illustrates coating weights which have been obtained with a 38 millimeter wide pattern deposited on a substrate moving at about from 70 meters per minute to about 350 meters per minute, with the  
20 shaded area of the graph (Fig. 7) illustrating the proven operating ranges.

As noted above, coatings are produced in varying weights. Such coatings can be varied from 0% open or impervious to about 25% open or porous.

25 It will be appreciated that various sizes, spacings, pressures and selections of materials can be utilized. Thus, for example, the hot melt might be started at 2 mm of substrate movement after air start

-24-

up, and the air flow stopped at 5 mm of substrate movement beyond extrusion shut off, for substrate speeds of about 70 meters/minute.

5 It will also be appreciated that the particular coating pattern produced by the apparatus and methods described above can either be porous or impervious and that the coating patterns are preferably produced in a discrete fashion on discrete substrates, for example, with good, square, sharp cut-on and cut-  
10 off and no stringing for the leading or trailing edges of the pattern, while at the same time, the sides of the pattern deposited are also parallel and sharp.

Accordingly, the invention provides for intermittent non-contact coating operation with sharp,  
15 square-edged patterns and no stringing for a variety of applications, including lamination of the substrate to which the patterns are applied to some other substrate or component. These and other modifications and advantages of the invention will become readily  
20 apparent to those of ordinary skill in the art without departing from the scope hereof, and the applicant intends to be bound only by the claims appended hereto.

WE CLAIM:

-25-

1. Apparatus for producing a coating for application to a substrate, said apparatus comprising:

a slot nozzle having an extrusion channel and an elongated slot outlet disposed along said channel through which coating material moving through said channel is extruded;

at least one air slot proximate said slot outlet for impinging at least one air stream onto a coating material exuding from said slot outlet to produce a fibrous web of coating material; and

means in said channel extending at least to a position proximate said slot outlet and for dividing said slot outlet into a plurality of slot outlets from which coating material exudes;

wherein said coating material exuding from each said slot outlet merges into coating material exuding from adjacent slot outlets to form a continuous coating web prior to impingement of air thereon.

-26-

2. Apparatus as in claim 1 wherein said dividing means extends outwardly beyond said slot outlet.

3. Apparatus as in claim 1 wherein said dividing means includes a shim having a plurality of juxtaposed elongated projections defining slots therebetween, said projections having tapered ends terminating at the outlet of said slot nozzle.

4. Apparatus as in claim 3 wherein the distance between two of the juxtaposed elongated projections is about twice the thickness of said shim.

5. Apparatus as in claim 1 wherein said dividing means includes a shim having a plurality of elongated juxtaposed projections defining slots therebetween, said projections having ends tapered to a point.

6 Apparatus as in claim 1 further including means for starting the flow of air prior to extrusion of coating material from said slot outlet and means for stopping the flow of air after extrusion of coating material has ceased.

-27-

7. Apparatus as in claim 6 including at least two air slots, one proximate each side of said slot outlet for impinging air therefrom onto coating material exuding from said slot outlet.

8. Apparatus as in claim 7 further including means for delaying impinging air from one of said air slots until after coating material exudes from said slot outlet and for continuing flow of air from said one slot until after extrusion of said coating material has ceased.

9. Apparatus as in claim 8 further including means for initiating flow of air from the other air slot before coating material is extruded and for ceasing flow of air from said other air slot before extrusion of said coating material ceases.

10. Apparatus as in claim 1 wherein said slot nozzle is disposed in a slot nozzle die comprising:

die halves defining an extrusion slot therebetween, said die halves having tapered projections with parallel inward facing surfaces forming said extrusion slot and tapered outer walls respectively partially defining inward surfaces of two air channels disposed at an angle with respect to said extrusion slot;

-28-

two air blocks, each having a tapered surface juxtaposed in operative disposition near one of said tapered outer wall such that one of said air channels is formed therebetween;

an air plenum in each said die block;

an air passage in each air block interconnecting an upper portion of each said plenum with a respective air channel; and

an air passage in each air block for feeding air to a lower portion of each said plenum.

11. Apparatus as in claim 10, including an air passage in each die half, each die half air passage operationally interconnected with one of said air passages in said air blocks for feeding air to said plenum therein.

12. Apparatus as in claim 10 wherein said air passages for feeding an air channel are defined by juxtaposed surfaces of said respective die halves and air blocks.

13. Apparatus as in claim 10 wherein said respective air plenums are defined by juxtaposed surfaces of said respective die halves and air blocks.

-29-

14. Apparatus for producing uniform adhesive webs for deposit onto substrates, comprising:

a slot nozzle die having die faces defining an elongated slot for receiving and passing adhesive material therethrough;

said elongated slot terminating in an elongated slot outlet;

a shim disposed between said die faces in said slot, said shim having a plurality of elongated projections defining slots therebetween,

said projections extending to said elongated slot outlet and defining between them a plurality of slot outlets through which adhesive material is extruded in a plurality of separate streams; and

means for impinging a flow of air on adhesive emanating from said slot nozzle die to produce a fibrous web of adhesive material.

15. A method of producing a fibrous web of adhesive comprising the steps of:

supplying adhesive material to the slot of a slot nozzle die;

dividing the adhesive material in said slot into a plurality of extruding streams of material emanating from said slot nozzle die in separate streams;

merging the streams together to form an unbroken stream of adhesive material; and

impinging a flow of air on both sides of said unbroken stream to produce a fibrous adhesive web for deposition onto a substrate.

16. A method as in claim 15 including starting and stopping the extrusion of coated material and the flow of impinging air at preselected different times to produce discrete coatings with even leading and trailing edges.

17. A method as in claim 16 wherein the starting and stopping of coating material and impinging air flow includes the steps of starting said impinging air flow, starting extrusion of coating material, stopping extrusion of coating material and stopping air flow.

18. A method as in claim 17 wherein the coating material is hot melt adhesive, and the method includes the steps of impinging air on the extruding coating material from both sides thereof, and the further steps of starting said air flow about 1700 micro seconds prior to the extrusion start, and stopping the air flow about 2100 micro seconds after the extrusion of coating material is stopped.

19. A method as in claim 17 wherein the method includes impinging air on the coating material from both sides thereof, and the further steps of:



-31-

starting a first flow of impinging air on one side of said slot nozzle;

then extruding coating material from said nozzle for application to a substrate;

then starting the second flow of impinging air onto said extruding coating material from another side of said slot nozzle;

stopping said first flow of impinging air;

then stopping said extrusion of material; and  
then stopping said second flow of impinging air.

1/5

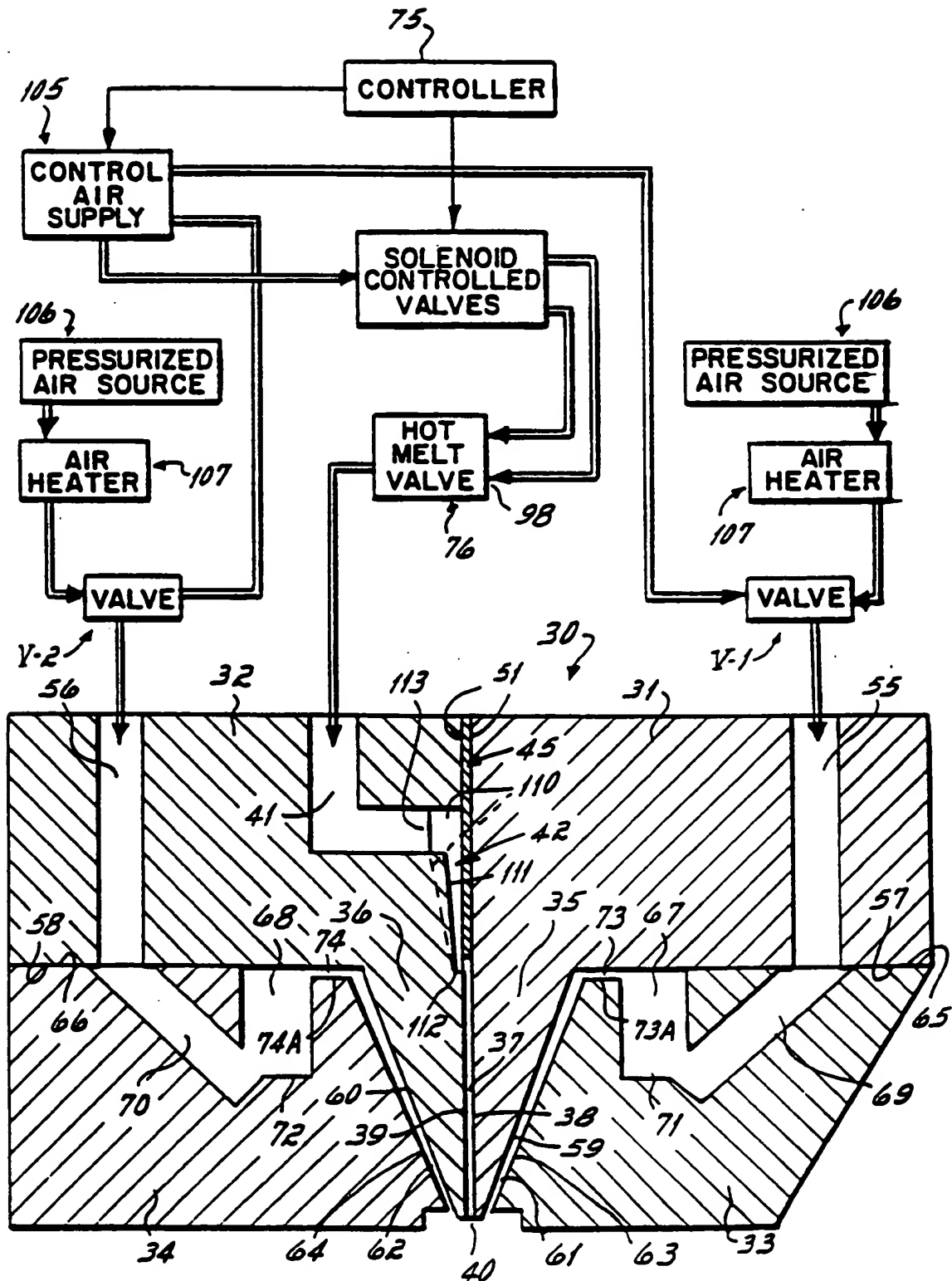
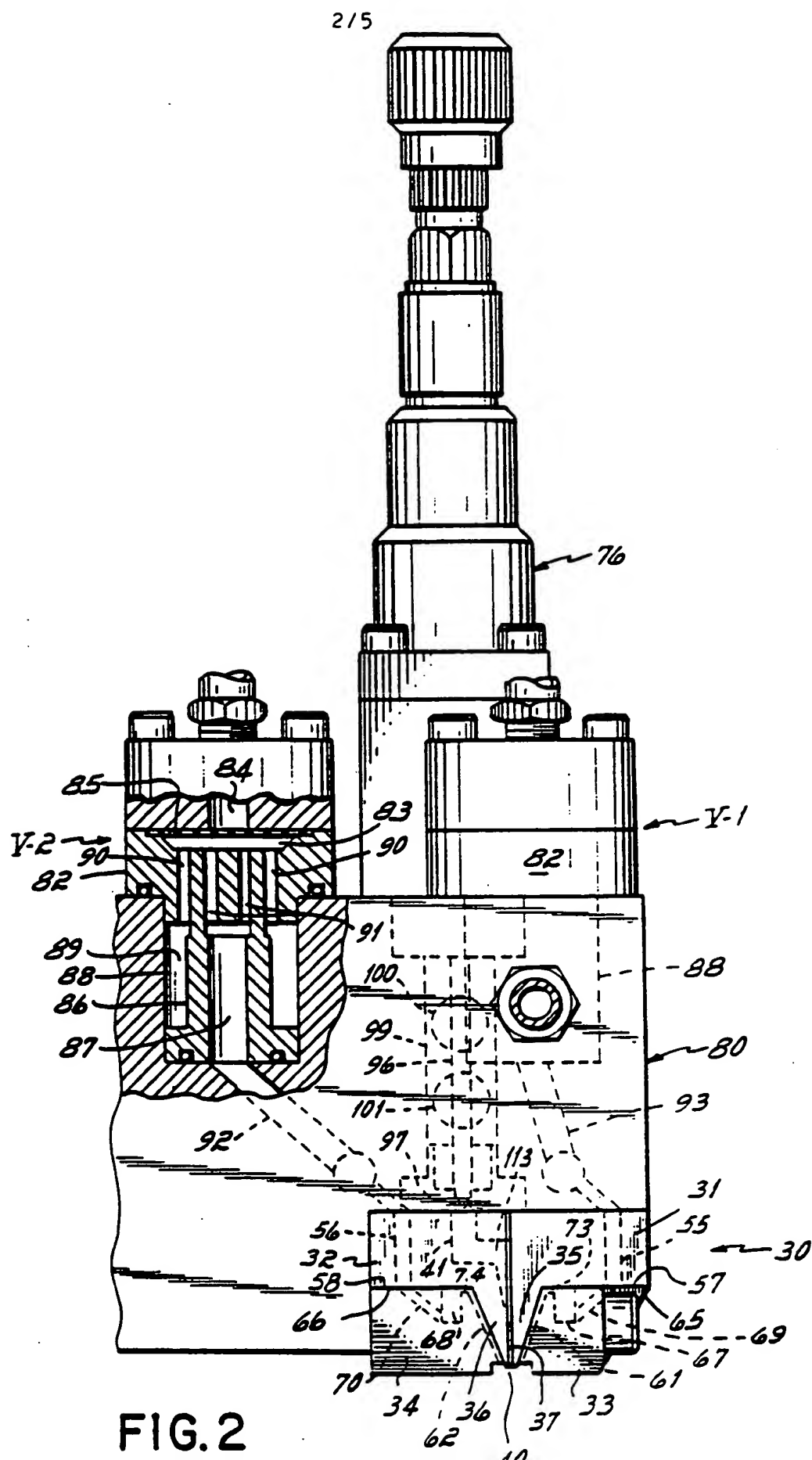
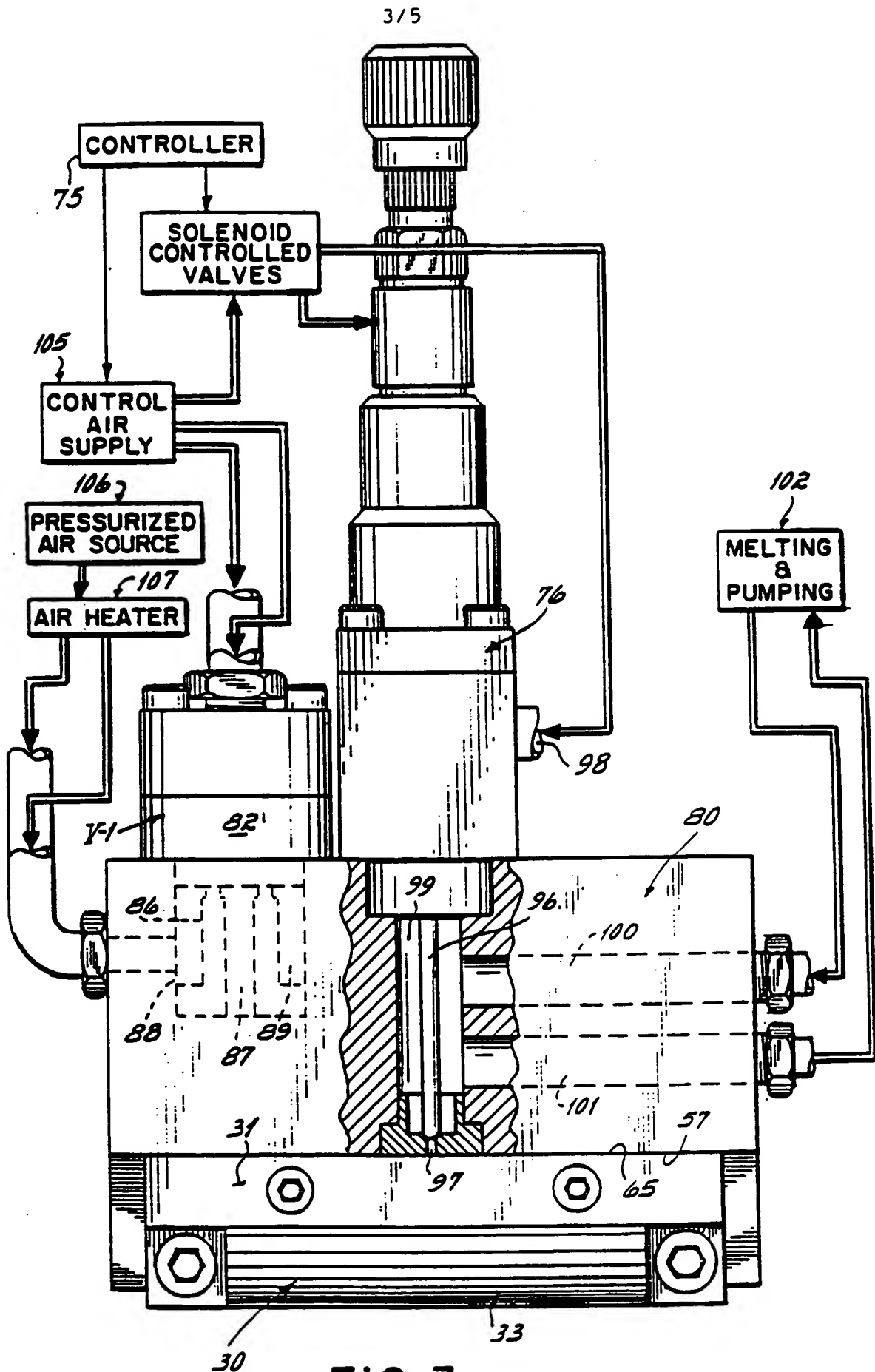


FIG. 1





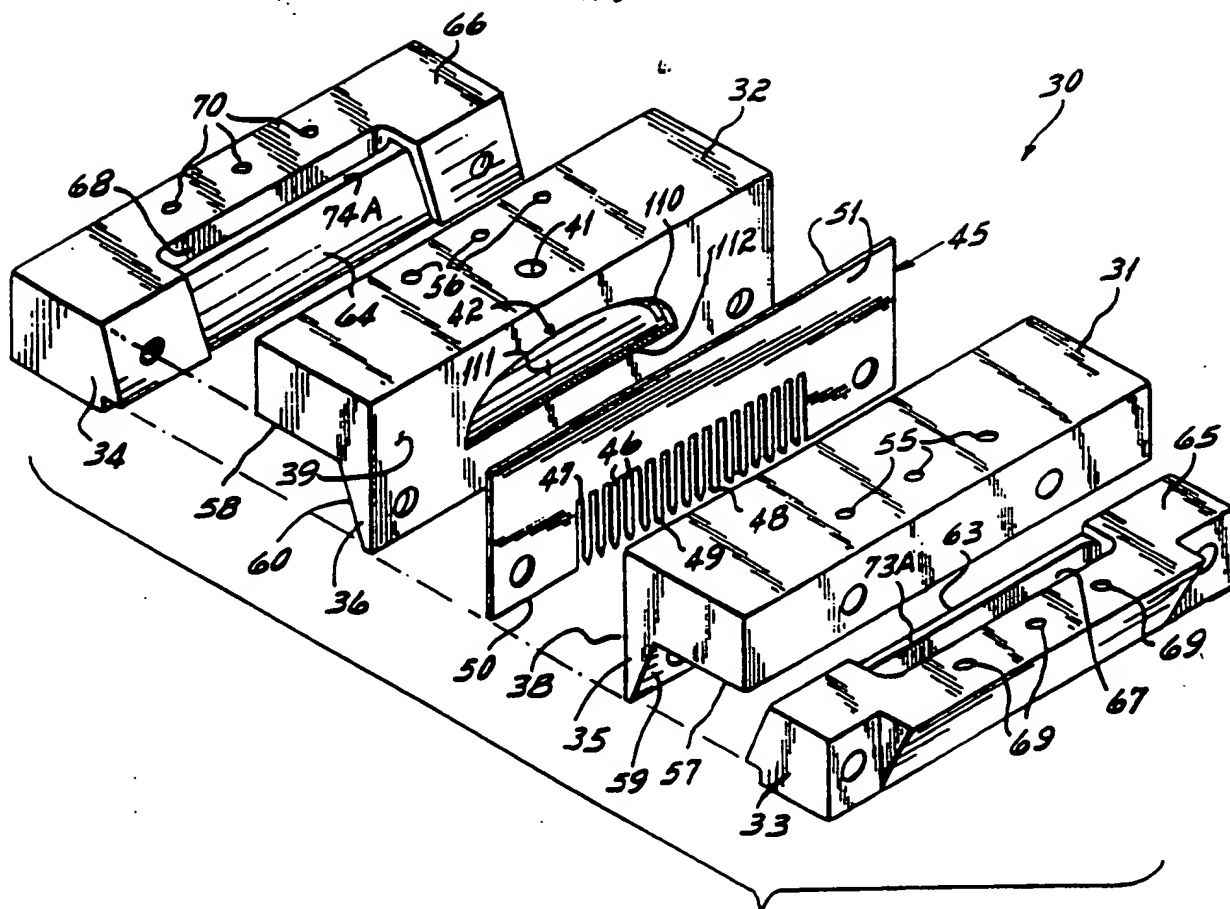


FIG.4

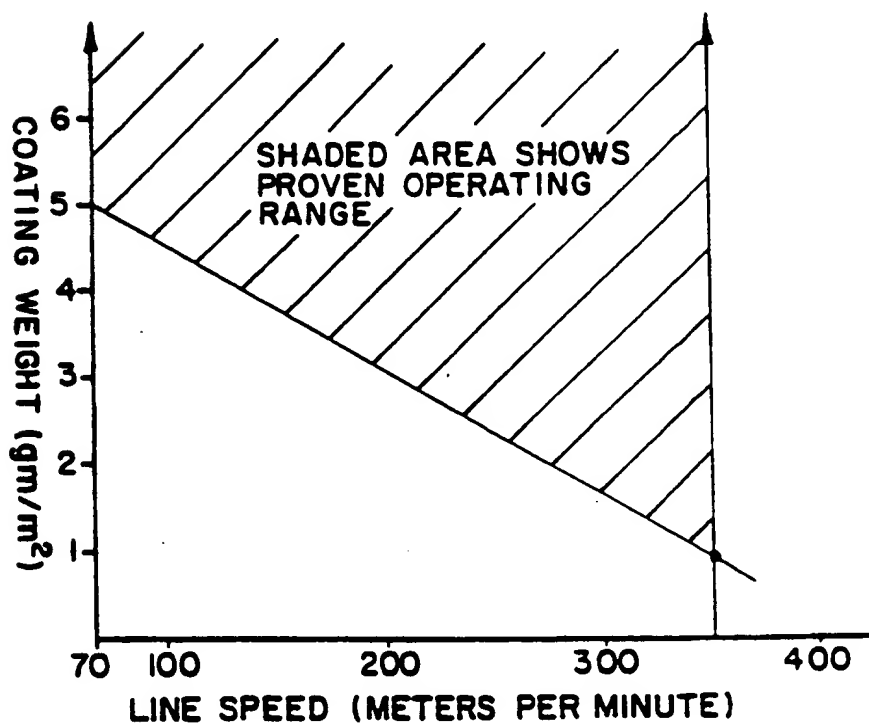


FIG 7

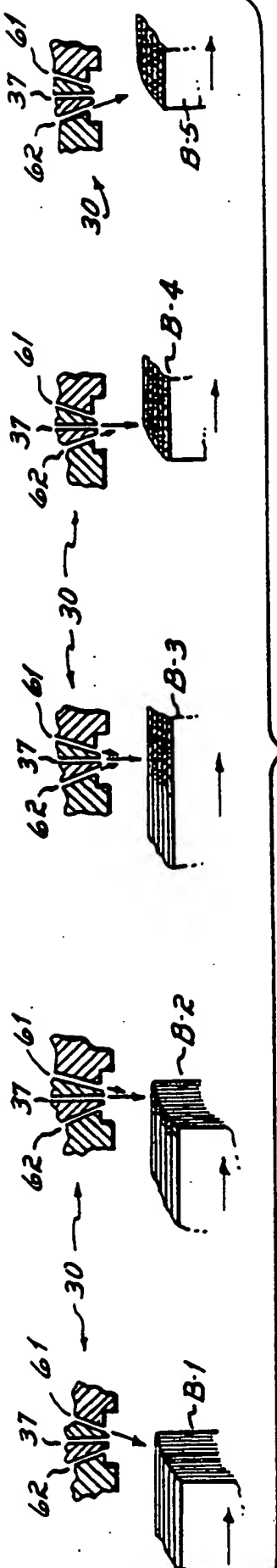


FIG. 5

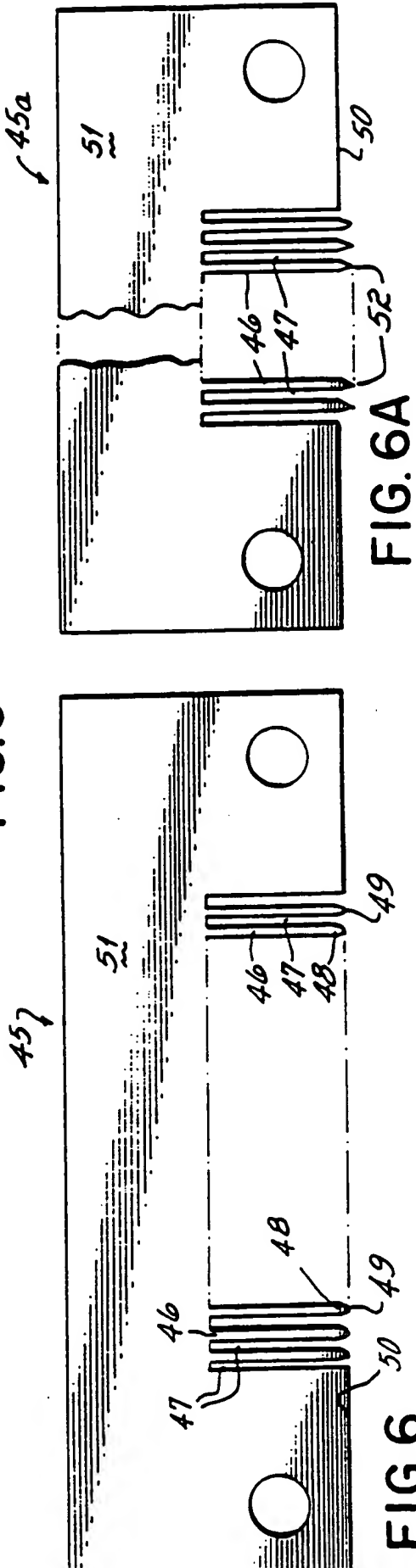


FIG. 6A

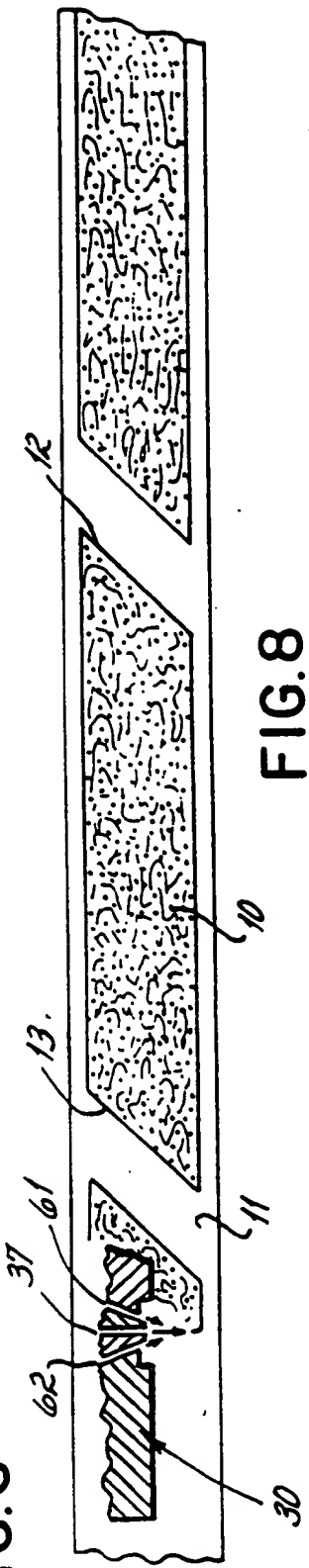


FIG. 8

## INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US 93/06434

## A. CLASSIFICATION OF SUBJECT MATTER

IPC5: B05B 1/16, B05D 1/12

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC5: B05B, B05C, B05D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, A, 4687137 (BENTLEY J. BOGER ET AL), 18 August 1987 (18.08.87), figures 1-2, abstract --	1,10
A	US, A, 4785996 (ROGER A. ZIECKER ET AL), 22 November 1988 (22.11.88), column 6, line 38 - column 7, line 20 --	1,10
A	WO, A1, 8900459 (NORDSON CORPORATION), 26 January 1989 (26.01.89), page 1, line 3 - line 9, figure 2, claim 1 --	1,10

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

## \* Special categories of cited documents:

- \*A\* document defining the general state of the art which is not considered to be of particular relevance
- \*B\* earlier document but published on or after the international filing date
- \*L\* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- \*O\* document referring to an oral disclosure, use, exhibition or other means
- \*P\* document published prior to the international filing date but later than the priority date claimed

\*T\* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

\*X\* document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

\*Y\* document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

\*&amp;\* document member of the same patent family

Date of the actual completion of the international search

24 Sept. 1993

Date of mailing of the international search report

10 -12- 1993

Name and mailing address of the International Searching Authority Authorized officer

European Patent Office, P.B. 5818 Patentaan 2  
NL-2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Johan von Döbeln

# INTERNATIONAL SEARCH REPORT

International application No.  
PCT/US 93/06434

## C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	<p>WO, A1, 9003847 (NORDSON CORPORATION), 19 April 1990 (19.04.90), page 6, line 3 - line 14, figures 1-2</p> <p style="text-align: center;">-- -----</p>	1,10



**INTERNATIONAL SEARCH REPORT**  
Information on patent family members

SA 76903

26/08/93

International application No.

PCT/US 93/06434

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US-A- 4687137	18/08/87	CA-A- 1250743 EP-A,B- 0237746 JP-A- 62266157 US-A- 4874451	07/03/89 23/09/87 18/11/87 17/10/89
US-A- 4785996	22/11/88	AU-B- 595998 AU-A- 1504588 CA-A- 1263808 JP-A- 63283774	12/04/90 27/10/88 12/12/89 21/11/88
WO-A1- 8900459	26/01/89	AU-B- 598437 AU-A- 2259588 EP-A- 0368914 JP-T- 2504235 US-A- 4774109 US-A- 4844004	21/06/90 13/02/89 23/05/90 06/12/90 27/09/88 04/07/89
WO-A1- 9003847	19/04/90	AU-B- 612550 AU-A- 4028489 AU-A- 4413489 EP-A- 0362548 EP-A- 0438478 JP-A- 2139058 JP-T- 4500928 US-A- 4911956 US-A- 4957783	11/07/91 12/04/90 01/05/90 11/04/90 31/07/91 29/05/90 20/02/92 27/03/90 18/09/90